

Work Order ID 65835

Wednesday, January 26, 2011 11:31:44 AM



Page 1

Item ID: D3778-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 1/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 2/7/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: PL Date: 11-01-26

Tooling:

Date:

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3778 | Rev A | | | | | | | | |

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3778 ☐ Dwg Rev: A ☐ Prog Rev: A ☐

****grain direction along 2.34" ****☐ 2-Deburr if necessary

5052 . 090

B11-2-7



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-2-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/12/11



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|--|-------------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 Brake NC Brake NC | NC BRAKE Memo 1-deburr | 0.00 0.00 | | | | | | | |
| | | <input type="checkbox"/> 2-Bend as per Dwg D3778 | SA 11/02/08 | | | | | | |
| 140 QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | | | | |
| | | | Sul 02/08 | | | | | | |
| 150 HandFinish Hand Finishing | Chemical Conversion Coat per QSI005 4.1 Memo | 0.00 0.00 | | | | 8 | 6 | 11/02/08 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 65835

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Page 3

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Item Name: Bracket

Start Date: 1/26/2011 Start Qty: 6.00

Required Date: 2/7/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M112588.

Memo

0.00

Powder Coating

START TIME:

3:40

OVEN TEMPERATURE:

520° FINISH TIME:

4:10

8 BL 11-02-9.

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 d. H 11/02/10

180

Identify as per dwg & Stock Location:

227

0.00



Packaging

Memo

0.00

Packaging

164/2/10 (8)

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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Page 4

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Required Date: 2/7/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/10 *[Signature]**MP*
11-02-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 11:31:48 AM

Page 1

Work Order ID: 65835

Parent Item: D3778-1

Parent Item Name: Bracket



Start Date: 1/26/2011

Required Date: 2/7/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue 08-04-15 DD verified by:EC
 IPP Rev:B 08-05-14 revA as per ECN1171 DD verified by:EC
 IPP Rev:C 08-05-22 add powder coating DD verified by:ec

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M5052H32S.090 | | Purchased | No | | | 100 | sf | 29.3000 | 0.0934 | 0.589895 | .8 | | |
| | | | | | | | | | | | | | |

5052-H32 .090 Sheet

Location

Loc Qty

Loc Code

MAT22

29.3

100782

0.8

3019

28.5

3014

8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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|------------------------------|---------------|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 6583F |
| Description: Bracket | | Part Number: | D3778-1 |
| Inspection Dwg: D3778 | Rev: A | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.098 | +0.004/-0.001 | .101 | ✓ | | VIBO2 | |
| 0.30 | +/-0.030 | .302 | ✓ | | | |
| 0.30 | +/-0.030 | .299 | ✓ | | | |
| Ø0.635 | +/-0.005 | .637 | ✓ | | | |
| 0.400 | +/-0.010 | .400 | ✓ | | | |
| 0.468 | +/-0.010 | .468 | ✓ | | | |
| 1.50 | +/-0.030 | 1.501 | ✓ | | | |
| 2.750 | +/-0.010 | 2.753 | ✓ | | | |
| 2.34 | +/-0.030 | 2.344 | ✓ | | | |
| 5.75 | +/-0.030 | 5.751 | ✓ | | | |
| 0.090 | +/-0.010 | .087 | ✓ | | | |
| Ø0.500 | +/-0.005 | .501 | ✓ | | | |
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|---------------------|--------|--------------------|----------|----------------------------|-----|
| Measured by: | B | Audited by: | S | Prototype Approval: | N/A |
| Date: | 11-2-7 | Date: | 11/02/07 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 08.10.07 | New Issue | KJ/DD | B |

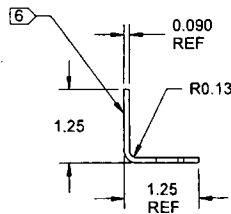
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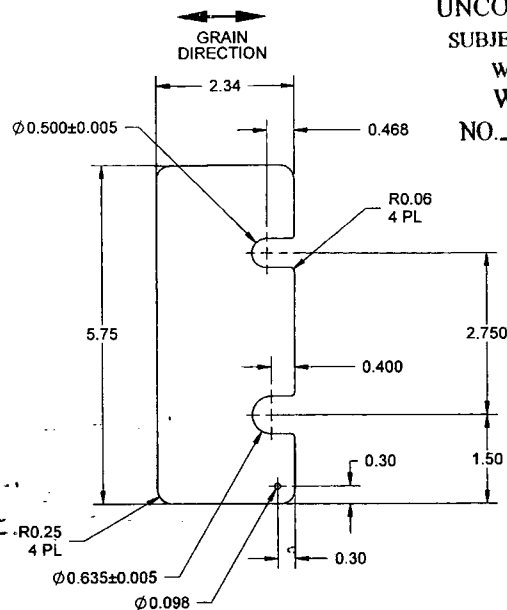
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NOTE: Date & initial all entries



D3778-1 BRACKET



D3778-1F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65835

p/11-01-26



RELEASED
08-05-11

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32.090)
OR
6061-T6/-T62 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T60.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3778-1" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.11 lbs

| | | | | | |
|------------|----------|---|---|----|----------|
| A | | NEW ISSUE | | PH | 08.04.11 |
| REV. | | DESCRIPTION | | BY | DATE |
| DESIGN | P4 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | |
| DRAWN | P4 | | | | |
| CHECKED | SP | DRAWING NO. | REV. A | | |
| MFG. APPR. | WJ | D3778 | SHEET 1 OF 1 | | |
| APPROVED | WJ | TITLE | SCALE | | |
| DE APPR. | WJ | BRACKET | NTS | | |
| DATE | 08.04.11 | | COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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